

Work Order ID 97070

97070

Page 1

February-14-13 1:35:08 PM

Item ID: D3684-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: LEG ASSEMBLY
 Start Date: 2/14/13 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 2/25/13 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 13-02-15 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3684 | E | | | | | | | | |
| 100 | Pick Kit | 0.00 | | | | 3 | 0 | | FF 13-05-06 |
| *100* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 110 | Small Fab | 0.00 | | | | 3 | 0 | | FF 13-05-06 |
| *110* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 | | | | | | | | |
| | 2-Assemble as per Dwg D3684 | | | | | | | | |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Work Order ID 97070

97070

Page 2

February-14-13 1:35:08 PM

Item ID: D3684-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: LEG ASSEMBLY
 Start Date: 2/14/13 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 2/25/13 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | 3 | | | |
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location Memo | 0.00 0.00 | | | | 3 | | | |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

13-05-8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|---|---|---|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|---|---|---|--|---|

Picklist Print

February-14-13 10:49:01 AM

Page 1

Work Order ID: 97070
Parent Item: D3684-045
Parent Item Name: LEG ASSEMBLY

Start Date: 2/14/13

Required Date: 2/25/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified
By:DD
DD VERF:JLM
IPP REV:C AS PER REV D 10-
IPP REV:D 13.01.24 PER ECN12-693

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3688-5 Stud | | Manufactured | No | 97 230 | | 110 | Each | 0.0000 | 1 | 3 | FF | 13-05-06 | |
| D3689-1 SLEEVE | | Manufactured | No | | | 110 | Each | 18.0000 | 1 | 3 | FF | 13-05-06 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | FG | | 2 | | | | | | | |
| | | | | 83358 | | 2 | | | | | | | |
| | | | | GA | | 16 | | | | | | | |
| | | | | 72117 | | 1 | | | | | | | |
| | | | | 88239 | | 8 | | | | | | | |
| | | | | 89987 | | 7 | | | | | | | |
| D3691-041 Stud Assembly | | Manufactured | No | 97520 | | | Each | 0.0000 | | 3 | FF | 13-05-06 | |
| NASS09L12C Nuts | | Purchased | No | | | 110 | Each | 47.0000 | 1 | 3 | FF | 13-05-06 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST276 | | 47 | | | | | | | |
| | | | | 121349 | | 40 | | | | | | | |
| | | | | 121652 | | 7 | | | | | | | |
| NASS09-12C Nuts | | Purchased | No | | | 110 | Each | 101.0000 | 1 | 3 | FF | 13-05-06 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST277 | | 101 | | | | | | | |
| | | | | 121162 | | 20 | | | | | | | |
| | | | | 121274 | | 25 | | | | | | | |
| | | | | 121556 | | 6 | | | | | | | |
| | | | | 121827 | | 50 | | | | | | | |

NCR: Yes / No

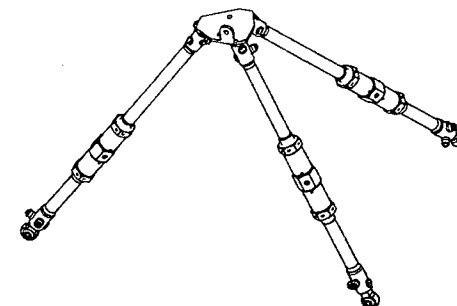
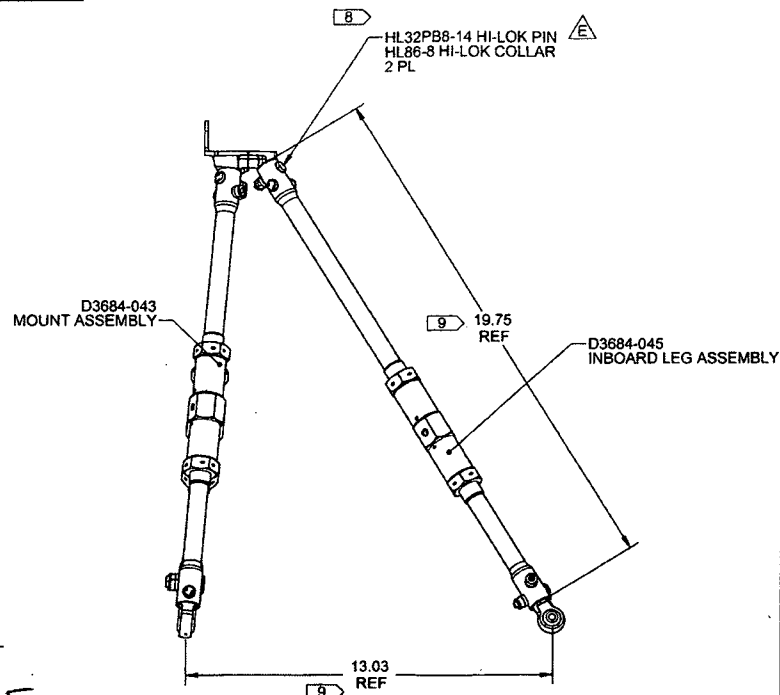
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | |
|---|------|------|---|---|-------------------|---|-------------|--------------|---|--|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION <div style="display: flex; justify-content: space-around;"> <div style="text-align: right;"> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> </div> <div style="text-align: right;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div style="text-align: right;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div style="text-align: right;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div style="text-align: right;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | |

| ITEM | QTY -041 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-----------------------|
| 1 | X | D3684-041 | TRIPOD MOUNT ASSEMBLY |
| 2 | 1 | D3684-043 | MOUNT ASSEMBLY |
| 3 | 1 | D3684-045 | INBOARD LEG ASSEMBLY |
| 5 | 2 | HL32PB8-14 | HI-LOK PIN |
| 6 | 2 | HL86-8 | HI-LOK COLLAR |



STAP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 97070 MLS
13-02-15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.9 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-043 WITH D3684-045 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/3/-5 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES.
- 10) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED

D3684-041 TRIPOD MOUNT ASSY 10

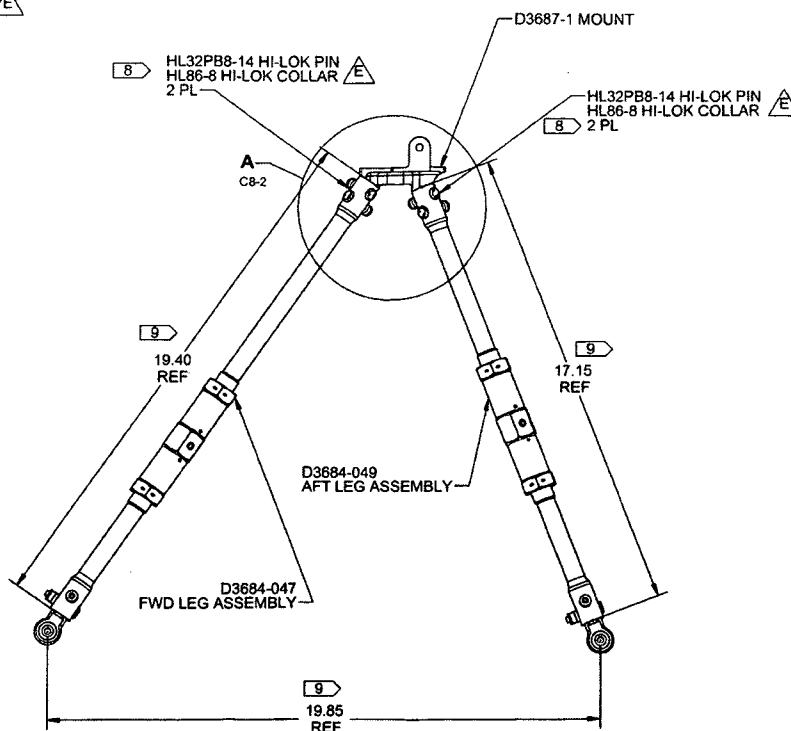
RELEASED
2013-01-22
WJ

| E | REMOVE AN3C-12A BOLT, D3692-1 SPACER AND MS21043-3 NUT, REPLACE WITH HL32PB8-14 HI-LOK PIN, HL86-8 HI-LOK COLLAR (ZN D4-1, ZN D4-2, ZN D5-2); REFORMAT NOTES SECTION AS PER QSI 043, CHANGE ASSEMBLY ADHESIVES LISTED IN NOTES (ZN A8-1, ZN A8-2, ZN A8-3, ZN A8-4, ZN A8-5) REF NCR12-2074. | DB | 12.12.05 |
|------------|--|---|--------------|
| D | 13.03 WAS 13.10 (ZN B5-1); 19.75 WAS 19.87 (ZN C4-1); 19.40 WAS 19.52 (ZN C6-2); 17.15 WAS 17.27 (ZN C4-2); 19.85 WAS 20.24 (ZN B5-2); 20.98 WAS 21.09 (ZN C5-3); 20.62 WAS 20.74 (ZN C5-4); 18.37 WAS 18.49 (ZN C6-5) | RF | 10.03.03 |
| C | NOW ASSEMBLED USING SEALANT (ZN A8-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1) | RF | 08.12.15 |
| B | 19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C5-4); 6.95 WAS 6.88 (ZN D5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS | RF | 08.11.24 |
| A | NEW ISSUE | RF | 08.05.22 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | DB | | |
| CHECKED | MB | DRAWING NO. | REV. E |
| MFG. APPR. | JLM | D3684 | SHEET 1 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TRIPOD MOUNT ASSY | NTS |
| DATE | 12.12.05 | <small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small> | |

| ITEM | QTY .043 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|----------------|
| 1 | X | D3684-043 | MOUNT ASSEMBLY |
| 2 | 1 | D3687-1 | MOUNT |
| 3 | 1 | D3684-047 | FWD LEG ASSY |
| 4 | 1 | D3684-049 | AFT LEG ASSY |
| 5 | 4 | HL32PB8-14 | HI-LOK PIN |
| 6 | 4 | HL86-8 | HI-LOK COLLAR |

DETAIL A
SCALE 2X
C5-2

ORIENT HI-LOK PINS AS SHOWN
(INSERT PIN FROM THIS SIDE)
TO ENSURE CLEARANCE FOR
ENGINE THROTTLE LINKAGE



D3684-043 MOUNT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 6.6 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047/-049 WITH D3687-1 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

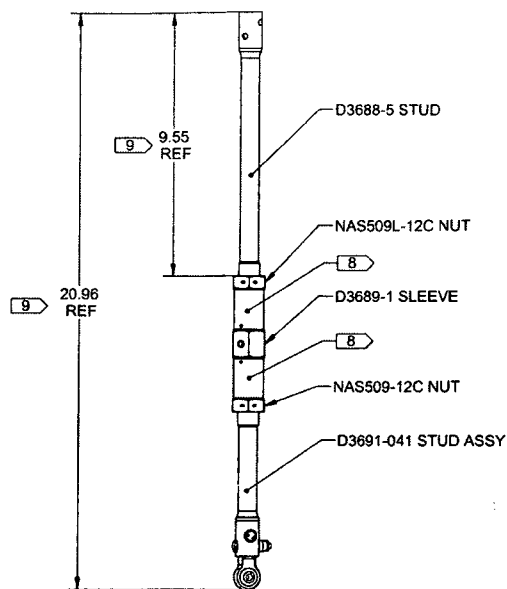
| | | | |
|------------|--------------------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | MB | DRAWING NO. | REV. E |
| MFG. APPR. | JLM | D3684 | SHEET 2 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TRIPOD MOUNT ASSY | NTS |
| DATE | 12.12.05 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

RELEASED
2013-01-22

97070

97070

| ITEM | QTY .045 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|----------------------|
| 1 | X | D3684-045 | INBOARD LEG ASSEMBLY |
| 2 | 1 | D3688-5 | STUD |
| 3 | 1 | D3689-1 | SLEEVE |
| 4 | 1 | D3691-041 | STUD ASSY |
| 5 | 1 | NAS509L-12C | NUT |
| 6 | 1 | NAS509-12C | NUT |



D3684-045 INBOARD LEG ASSEMBLY

RELEASED
2013-01-22
MD

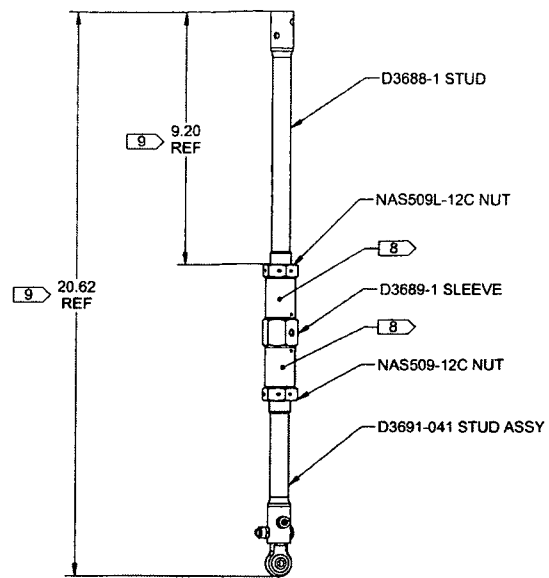
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 3.1 lbs
- 8) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 9) DIMENSION SHOWN IS WHEN D3688-5 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | MB | DRAWING NO. | REV. E |
| MFG. APPR. | JLM | D3684 | SHEET 3 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TRIPOD MOUNT ASSY | NTS |
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97070

| ITEM | QTY -047 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|------------------|
| 1 | X | D3684-047 | FWD LEG ASSEMBLY |
| 2 | 1 | D3688-1 | STUD |
| 3 | 1 | D3689-1 | SLEEVE |
| 4 | 1 | D3691-041 | STUD ASSY |
| 5 | 1 | NAS509L-12C | NUT |
| 6 | 1 | NAS509-12C | NUT |



D3684-047 FWD LEG ASSEMBLY

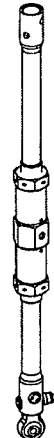
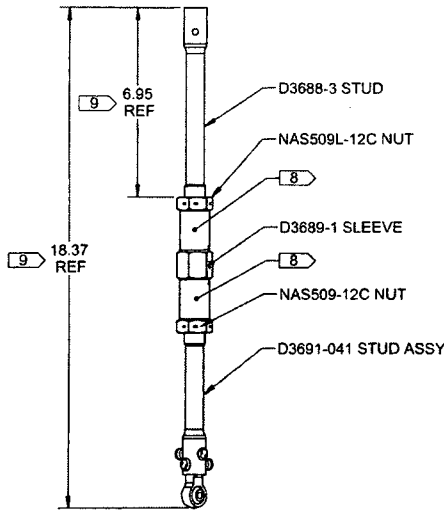
RELEASED
2013-01-22

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 3.08 lbs
 - 8) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
 - 9) DIMENSION SHOWN IS WHEN D3688-1 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | MB | DRAWING NO. | REV. E |
| MFG. APPR. | JLM | D3684 | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TRIPOD MOUNT ASSY | NTS |
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97070

| ITEM | QTY -049 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|------------------|
| 1 | X | D3684-049 | AFT LEG ASSEMBLY |
| 2 | 1 | D3688-3 | STUD |
| 3 | 1 | D3689-1 | SLEEVE |
| 4 | 1 | D3691-041 | STUD ASSY |
| 5 | 1 | NAS509L-12C | NUT |
| 6 | 1 | NAS509-12C | NUT |



D3684-049 AFT LEG ASSEMBLY

RELEASSED
2013-01-22

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.85 lbs
 - 8) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
 - 9) DIMENSION SHOWN IS WHEN D3688-3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | MB | DRAWING NO. | REV. E |
| MFG. APPR. | JLM | D3684 | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TRIPOD MOUNT ASSY | NTS |
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